

Work Order ID 62247

Wednesday, September 22, 2010 3:39:28 PM



Page 1

Item ID: D2805-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Stop				
Start Date: 9/22/2010	Start Qty: 12.00			
Required Date: 9/30/2010	Req'd Qty: 12.00			
Reference:				

Cust Item ID:
Customer:

Approvals:	Process Plan: <u>H</u>	Date: <u>10-9-23</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2805	Rev B

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Bar: 3.150" Long +0.010/-0.030"								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr Identify as D2805-1								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

12

12

12

10/11/16

10/11/16

10/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62247

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Page 2

Item ID: D2805-1

Accept

Revision ID:

Item Name: Stop

Start Date: 9/22/2010 Start Qty: 12.00

Required Date: 9/30/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 10/11/17

12

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7 10/11/17

12

0

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BL 10-11-17

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Item ID: D2805-1

Accept

Revision ID:

Item Name: Stop

Start Date: 9/22/2010 Start Qty: 12.00

Required Date: 9/30/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location 22

0.00



Packaging

Memo

0.00

Packaging

10/11/18
sf
100

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00


Quality Control

10/11/19
JF
10-11-19

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 3:39:33 PM

Page 1

Work Order ID: 62247

Parent Item: D2805-1

Parent Item Name: Stop



Start Date: 9/22/2010

Required Date: 9/30/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B□00.11.14□Revised Finishing step to Acid etch and Alodine□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	13.1762	0.2625	3.315789			



6061-T6 Bar 1.50 x 1.50



Location

Loc Qty

Loc Code

MAT10

13.1762

107244

1

107432

12.1762

3.315789 SN 10/11/10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42247
Description: Stop		Part Number:	D2805-1
Inspection Dwg: D2805 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.975	/		Ueln	SD-9
0.240	+/-0.010	.239	/			
0.100 chamfer	+/-0.010	.100	/			
1.420	+/-0.001	1.420	/			
1.125	+/-0.010	1.124	/			
0.250	+0.005/-0.000	.250	/			
0.250	+/-0.010	.250	/			
1.500	+/-0.010	1.499	/			
1.000	+/-0.010	1.000	/			
0.875	+0.001/-0.000	.875	/			
Ø0.191	+0.005/-0.000	Ø.196	/			
2.689	+/-0.010	2.685	/			

Measured by:	SA	Audited by:	QMK	Preliminary Approval:	
Date:	10/11/16	Date:	10/11/17	Date:	

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	
C	10.06.04	0.438 dimension removed	KJ	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

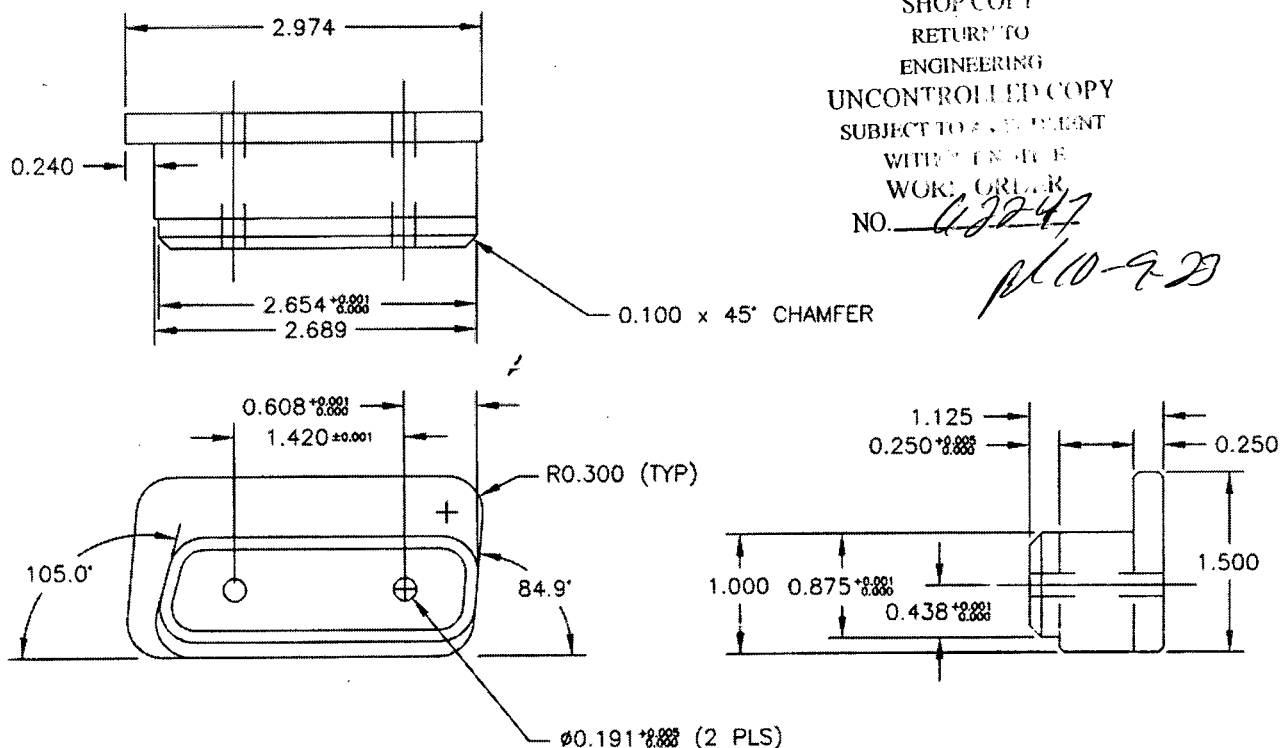
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DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

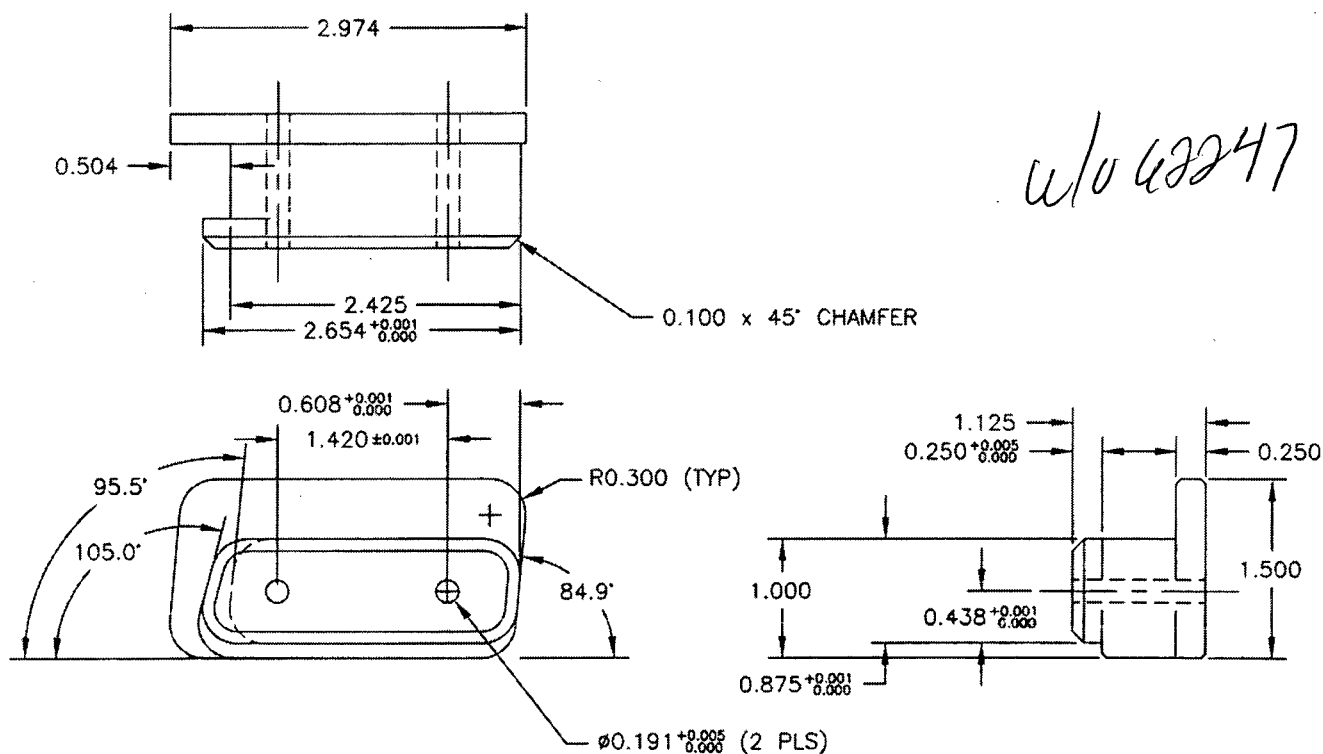
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
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